



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3849-3

Job Sheet 204088



Part No: D3849-3

Job Qty: 12 pcs

Part Name: Plate



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/2/19

Job Tracking No:

Due Date: 1/7/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D3849 REV.G IPP RevA: New issue DD verified by:EC IPP Rev:B 12.09.11 AS PER DWG REV.D DD
VERF:JLM

Ship Via:

UNDER REVIEW
12-902

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	12 pcs		1/7/20	0.17	3.54	Waterjet - Flow		0-19/12/10
110	QC 2	12 pcs		1/7/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		0-19/12/10
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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120 QC 8	12 pcs	1/7/20	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
130 Small Fab - Brake NC - B4B	12 pcs	1/7/20	0.25 2.06	Small Fab - Brake - 1 - B4B	DAS 30 DEC 19 2019 9-8%
				Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	
210 QC 5	12 pcs	1/7/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
220 Packaging 3-1 - Stock - B4B	12 pcs	1/7/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	

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				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	12
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
230 QC 21 - SA	12	1/7/20	0.00 0.00	QC 21 - SA - 21	21
	pcs			QC 21 - SA - 70	70
				QC 21 - SA - 53	53

DEC 19 2019

Part Op 100 - 1-Cut as per Dwg D3849 Dwg Rev: G Prog Rev: G 2-Deburr if necessary
 Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)
 120 - (QC8- Inspect parts - second check)
 130 - (Form as per dwg)Form as per dwg using DT8179 & DT8155 BEND AS PER SECTION E-E
 210 - (QC5- Inspect part completeness to step on W/O)
 220 - (Identify as per dwg & Stock Location: Wt002-2)
 230 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	43.0200 sf (3.585 ea)	100-Waterjet - Flow - 1	5232151

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S18GA	43	372	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

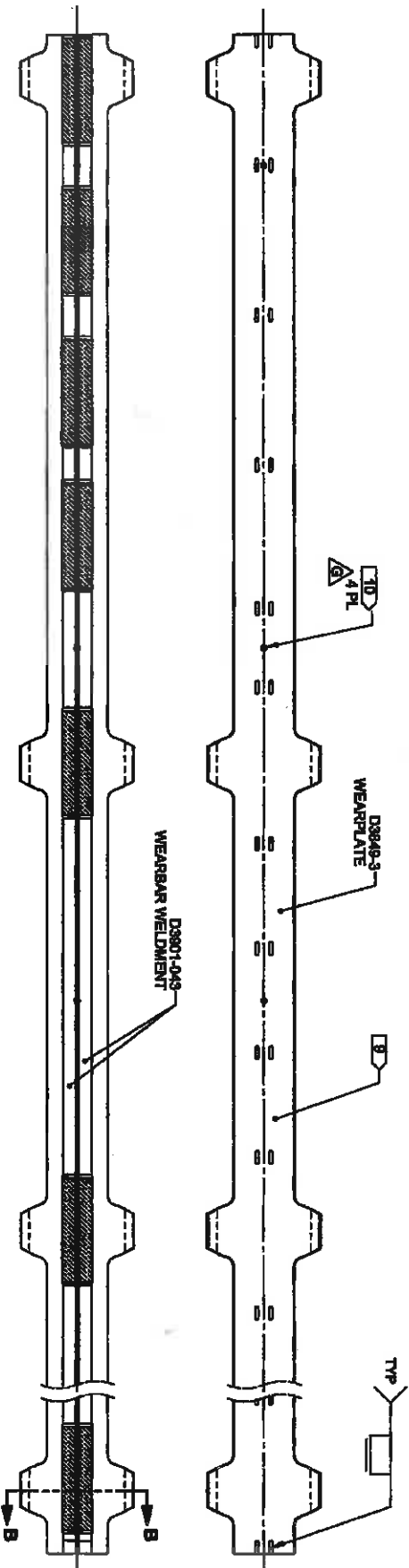
NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		MRB (QS1042)																													
Date : _____		Sequence #: _____		QTY Affected : _____		Disposition																													
Description Work Order Deviation				Completed By																															
				Lead hand / Supervisor																															
				QC / QA Coordinator																															
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Undeclared Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table>						Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Undeclared Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
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Mislabeled	Fit/Function	Off-set/Set-up																																	
Other/Details:																																			

QTY	P/N	DESCRIPTION
1	D3848-043	AFT WEARPLATE ASSY, STD GEAR
1	D3848-3	WEARPLATE
2	D3801-043	WEARBAR WELDMENT



D3848-043 AFT WEARPLATE ASSY, STD GEAR



- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART OSI 048 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY PER OSI 044 6.1
 - 7) WEIGHT: 8.01 LBS
 - 8) WELDING: PER OSI 004
 - 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART OSI 006 4.8.
 - 10) TRANSFER DRILL 00.100 HOLES FROM D3848-3 WEARPLATE TO D3801-043 WEARBARS, AFTER APPLYING TEXTURED COATING.

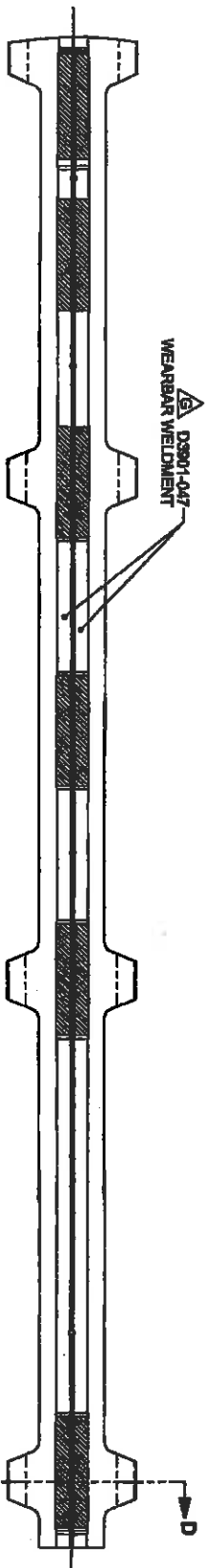
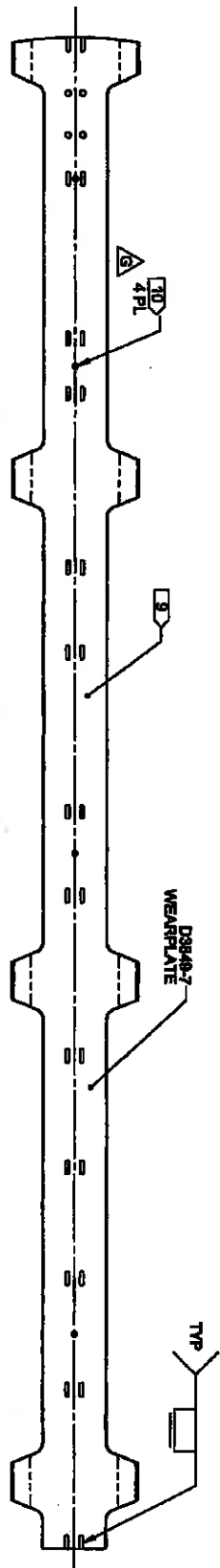
APPROVED

DESIGN	RF	DART AEROSPACE USA, INC.
DRAWN	ZF	HILLSBORO, OR
CHECKED	MM	REV. G
ENG. APPR.	DO	D3848
APPROVED	NO	TITLE
DE APPR.	DS	WEARPLATE ASSY
DATE	18.08.11	SCALE
		NTS

UNDER REVIEW
URF 19-902 19.10.15 NO

RELEASED
2019 OCT 15

QTY	P/N	DESCRIPTION
1	D3849-047	FWD WEARPLATE, FLOAT GEAR
1	D3849-7	WEARPLATE
2	D3901-047	WEARBAR WELDMENT



D3849-047 FWD WEARPLATE, FLOAT GEAR



- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART CSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY PER CSI 044 6.1
 - 7) WEIGHT: 7.45 LB
 - 8) WELDING: PER CSI 004
 - 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART CSI 006 4.9.
 - 10) TRANSFER DRILL 0.0188 HOLES FROM D3849-7 WEARPLATE TO D3901-047 WEARBARS, AFTER APPLYING TEXTURED COATING

APPROVED

DESIGN	REV	DATE	DESCRIPTION
DRAWN	2F		DART AEROSPACE USA, INC.
CHECKED	MM		HILLSBORO, OR
INFG. APPR.	DD		REV. G
APPROVED	NO		8 SHEET 5 OF 10
DE APPR.	DS		SCALE
DATE	19.06.11		MTS

UNDER REVIEW
URF 19-902 19.10.15 NO

3079 OCT 15 11

RELEASED

CONFIDENTIAL & NOT BE RELEASED TO THE PUBLIC
FOR THE USE OF THE UNITED STATES GOVERNMENT



2019 OCT 15 *gh*

UNDER REVIEW
URF 19-902 19.10.15 NO

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.040 THICK)
PER MIL.-S-0069 OR AMS 5613 OR 6824
OR ASTM A240 OR ASME SA240
REF. DART SPEC. M004S18GA
2) FINISH: NONE
3) TOLERANCES: PER DART AISI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 2.28 lbs

APPROVED

DESIGN	RF	DRAWING NO.	REV. G
DRAWN	ZF	D38-49	SHEET 6 OF 10
CHECKED	MW	TITLE	WEARPLATE ASSY
INFG. APPR.	DD	NO.	
APPROVED	NO	DATE	19.08.11
DE APPR.	DB		

DART AEROSPACE LTD		Work Order: 204088
Description: <u>Wear plate</u>		Part Number: D3849-3
Inspection Dwg: D3849	Rev: G	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
7.375	±0.005 -0.001	0.376	✓		VDC-A	
6.188	±0.005 -0.001	0.191	✓		Tape	
6.642	±1-0.010	6.642	✓			
7.72	±1-0.030	7.75	✓			
18.71	±1-0.030	18.75	✓			
36.63	±1-0.030	36.60	✓			
62.86	±1-0.030	62.87	✓			
67.02	±1-0.030	67.03	✓			
2.43	±1-0.030	2.45	✓			
2.45	±1-0.030	2.45	✓			
5.75	±1-0.030	5.76	✓			
9.75	±1-0.030	9.78	✓			
12.00	±1-0.030	12.00	✓			
13.75	±1-0.030	13.76	✓			
17.75	±1-0.030	17.76	✓			
23.75	±1-0.030	23.78	✓			
27.75	±1-0.030	27.76	✓			
30.00	±1-0.030	30.00	✓			
31.75	±1-0.030	31.80	✓			
35.75	±1-0.030	35.76	✓			
41.75	±1-0.030	41.76	✓			
43.50	±1-0.030	43.62	✓			
44.75	±0.005 ±1-0.030	44.74	✓			
50.26	±1-0.030	50.20	✓			
56.00	±1-0.030	56.00	✓			
61.75	±1-0.030	61.75	✓			
62.00	±1-0.030	62.00	✓			
13	±1-0.030	13	✓			
1.50	±1-0.030	1.50	✓			

Measured by: JRB	Checked by: <u>40</u> 9-89	QC Inspector:
Date: 12/12/19	Date: DEC 13 2019	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	